

Date: Thursday, 7/5/2007 8:15:55 AM  
 User: Kim Johnston

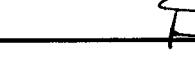
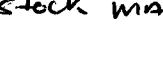
## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG EXTRUSION	
Job Number	: 33310				
Estimate Number	: 10305				
P.O. Number	: N/A		Part Number	: D2423	
This Issue	7/5/2007	S.O. No.	S.O. No.	Drawing Number : D2423 REV B1	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B1	
Previous Run	: 30062		Material	: N/A	
Written By			Due Date	: 8/12/2007	
Checked & Approved By	: <u>HD</u> 07.07.05		Qty:	300 Um: Each	
Comment	: Est G 04.09.02 Part Number D2423-108 changed to D2423 K J/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
2.0	D2423P	Lug Extrusion
Comment: Qty.: 1.0000 f(s)/Unit Total : 360.0000 f(s) Lug Extrusion		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
4.0	QC6	DIMENSIONAL CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
6.0	QC21	FINAL INSPECTION/W/O RELEASE
        		
Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion



207/08/10  
62

207/08/10

Num 07/09/25

I.D and stock material.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/01/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

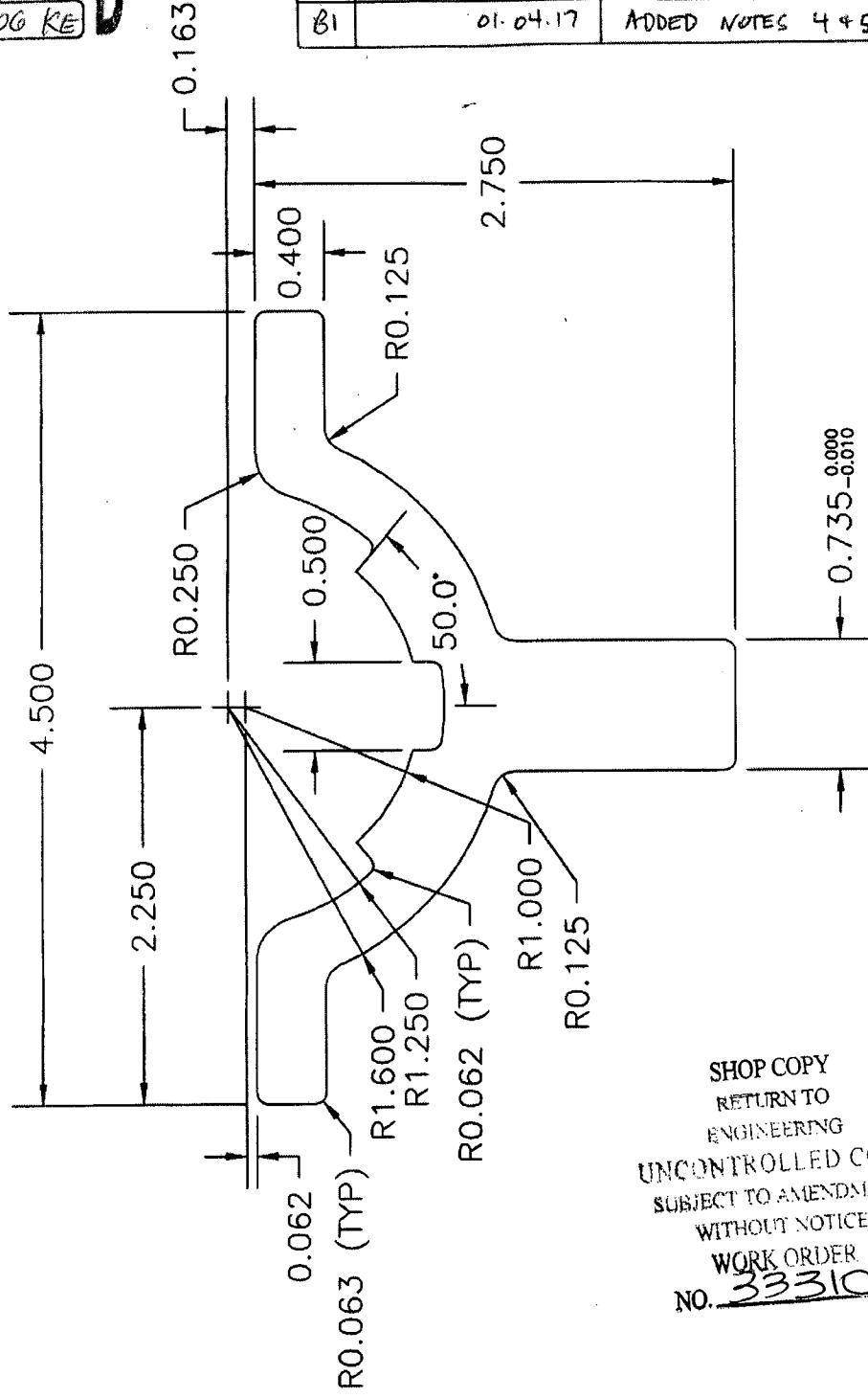
NOTE: Date & initial all entries

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
98/08/04	<i>[Signature]</i>	D2423	SHEET 1 OF 1
DATE		TITLE	SCALE
		LUG EXTRUSION	1:1
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4 & 5 <i>if CP</i>	

**RELEASED**  
98/08/06 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33310

1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING Carton NDALEX DIE # MS-18866 WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2423-108 IS 108" LONG)
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2423-108 IS 108" LONG)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



INDALEX LIMITÉE  
325, RUE AVRO  
POINTE-CI-AIRE (QUÉBEC) H9R 5W3  
TÉL.: 514-697-5120 • FAX: 514-694-8310

**PROFILÉS D'ALUMINIUM - ANODISATION - FABRICATION - PEINTURE**  
**ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING**

P/S# : 613841

NOTRE NUMERO DE COMMANDE  
OUR ORDER NO.

03/05/874

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ONT.

EXPÉDIÉ / SHIP TO

**INDICATIONS SPÉCIALES  
SPECIAL INSTRUCTIONS**

## MÊME - SAME

K6A1K7

CUSTOMER P. S. T. : \* 6122-5207

INDALEX G.S.T. REG NO: R136834041

Required Date:

DU CLIENT ST. NO.	T.P.S. G.S.T.	XXXXXX	TAXE DE VENTE PROV. PROV. SALES TAX	N° DE COMM. DU CLIENT CUST. ORDER NO.	DATE DE COMMANDE ORDER DATE	NOTRE DATE DE COMM. OUR ORDER DATE	CONDITIONS TERMS	
201355				1107106	1107106	1107106		
VENDEUR LES MAN	EXPEDIE PAR SHIP VIA	PAYE PRO	PERC. COL	C.A.D. C.O.D	F.A.B. FOB	EN BALLOTS BUNDLED AND TAPE	CARTONNE CARTONED	CARTONNE & INTERCALE CARTONED & INTERLEAVED
51	NOTRE CAMION				NOTRE USINE OUR PLANT			

OUR TRUCK		N. DE MATRICE INDALEX DIE NO.	DESCRIPTION DU CLIENT CUSTOMER DESCRIPTION	ALLIAGE ET TREMPAGE ALLOY AND TEMPER	LONGUEUR LENGTH	PRIX UNITAIRE UNIT PRICE
COMMANDE N° EN DET	ORDRE N° DET	Poids WEIGHT	PIÈCES PIECES	F. EXTRUDE ONLY		
1	622	40	MS 18866 D2423P	6061	T6	2743
			LUG EXTRUSION BUNDLE= 774736 774744			

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures

150

9001

## 5. Answers

## FEUILLE D'EMPAQUETAGE

# INDALEX

325 rue Avro  
Pointe-Claire QC H9R 5W3  
Téléphone (514) 697-5120  
Fax-similic (514) 694-8310

## Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD

Adresse / Address : 1270 ABERDEEN ST STREET

HAWKESBURY ONT;

KBA 1K7

# commande Indalex / Indalex order # : 7020534

# bon de commandé / Purchase order # : 4104

# de matrice / Die # : MS 18865 Description : LUG EXTRUSION

Alliage & tempérage / Alloy & temper : 6061-T6 ✓

# Contrôle / Control # : 20052-1

# Coulée / Cast # : 40861

Testé par : [Signature]

Testé le : 2007-07-18

	Un. requis Units required	Résultat actuel Actual results
Tension ultime (psi)	38 000	42725
Ultimate stress (psi)	35 000	40142
Contenu d'azote		12
Yield stress (psi)	8	92
% élongation à 2"		
% elongation in 2"		
Dureté Rockwell E (hrs)	88 @ 100	
Rockwell E Hardness (hrs)		

Composition chimique typique / Typical chemical composition :

Si	Fe	Cu	Mn	Mo	Cr	Sn	Ti
0.03	0.20 - 0.60	0.35 Max	0.10 Max				
0.035	0.60 - 0.90	0.35 Max	0.10 Max				
0065A	0.48 - 0.72	0.18 - 0.22	0.08 - 0.12	0.20 - 0.24	0.48 - 0.52	0.03 Max	0.03 Max
0061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.25	0.25 Max
0351	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	—	0.20 Max

Nous certifions que le matériau fourni renconrre les exigences chimiques telles qu'indiquées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 20018 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 20018 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Siélement votre,  
Yours truly,

Mark Oliver koklong  
Technician de la qualité  
Quality technician

Indalex Limited

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
---	---	---	---	---	---	---	---	---	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	-----